

Date: Wednesday, 3/12/2008 1:48:31 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE SPACER		
Job Number	37867		Part Number	D2935		
Estimate Number	11063		Drawing Number	D2935 REV B		
P.O. Number			Project Number	N/A		
This Issue	3/12/2008	S.O. No.	Drawing Revision	B		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	Due Date	3/22/2008	Qty:	40
Previous Run	36142		Um:	Each		
Written By	<u>JL</u> 08 03 12					
Checked & Approved By						
Comment	Est A 00.06.06 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s) Material: M6061-T6 0.080" Thick Batch <u>101276</u>	
2.0	WATER JET	FLOW WATER JET	
		<u>M</u> 08 03 14	(40)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>M</u> 08 03 14	(40)
4.0	QC8	SECOND CHECK	
		<u>E</u> 08 03 14 (40) carts	(40)
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		<u>B</u> 08-04-09	(40)
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE SPACER

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1-84/8(40)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-09

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37867
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

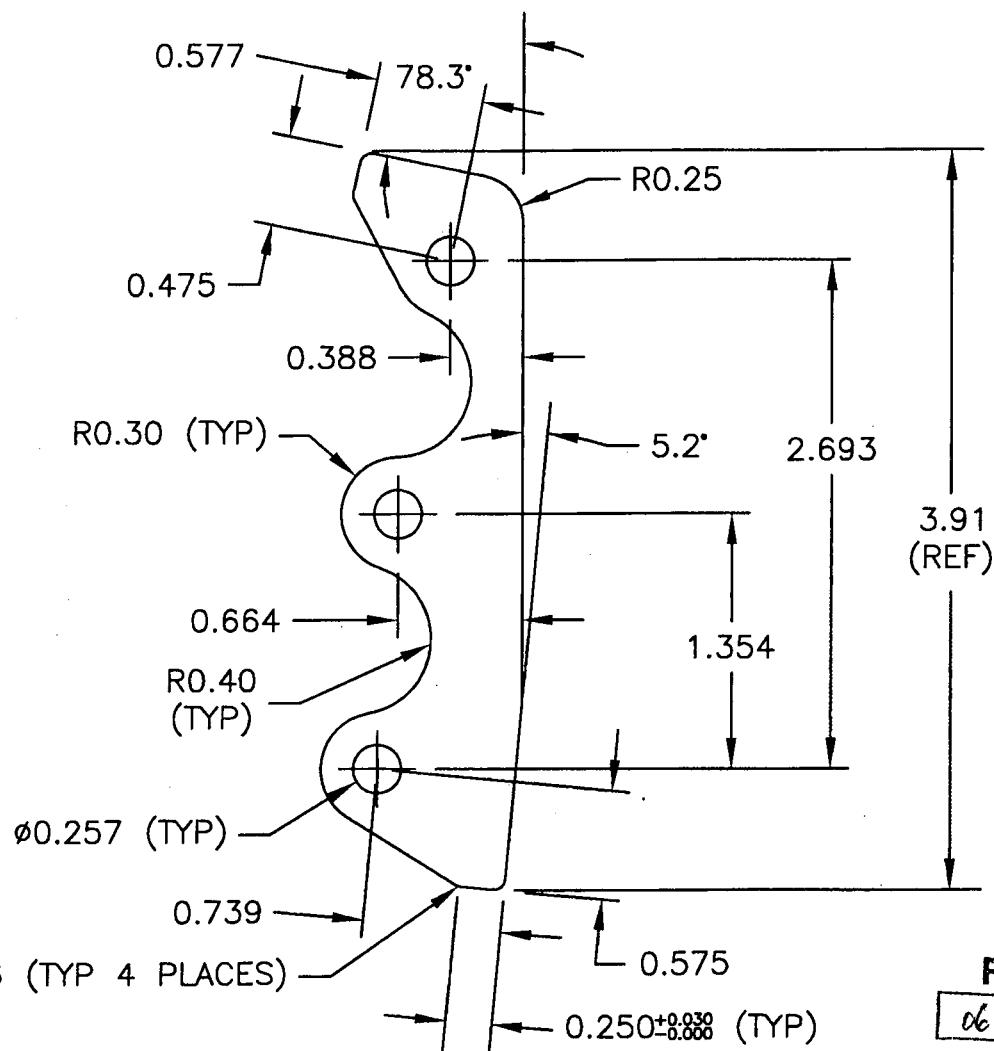
X First Article Prototype

Measured by:	<u>M. M.</u>	Audited by:	<u>J.</u>	Prototype Approval:	N/A
Date:	08/03/14	Date:	08/04/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	SJL

DART

DESIGN <i>TT</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37867

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